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(54) **METHOD FOR PRODUCING FEEDSTOCKS OF HIGH QUALITY LUBE BASE OIL FROM UNCONVERTED OIL OF FUELS HYDROCRACKER OPERATING IN RECYCLE MODE**

**METHODE ZUR ERZEUGUNG VON BASISCHMIERÖLEINSÄTZEN HOHER QUALITÄT AUS NICHT-UMGESETZTEM ÖL VON EINER IM REZIRKULATIONSBETRIEB ARBEITENDEN HYDROKRACKANLAGE**

**PROCEDE DE PRODUCTION D'HUILES DE DEPART UTILISEES DANS LA PREPARATION D'HUILES LUBRIFIANTES DE GRANDE QUALITE, A PARTIR D'UNE HUILE NON CONVERTIE PROVENANT D'UNE UNITE D'HYDROCRAQUAGE EN MODE RECYCLAGE**

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**US-A- 4 983 273**

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## Description

## BACKGROUND OF THE INVENTION

## 5 Field of the invention

**[0001]** The present invention relates to a method for producing feedstocks of high quality lube base oil from unconverted oil and, more particularly, to an improvement in efficiency along with a method for continuous production of high quality lube base oil from unconverted oil produced by a fuels hydrocracker in recycle mode.

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## Description of the Prior Art

**[0002]** In general, a fuels hydrocracker is a process for converting vacuum gas oil (VGO) produced from a vacuum distillation unit (V1) into fuel grade hydrocarbons such as diesel (as shown in Figure 1). The VGO feed contains a large amount of impurities such as sulfur, nitrogen, oxygen, metals and other materials not only harmful to the catalyst system but also undesirable in the products. Such impurities are removed in the hydrotreating reaction unit (R1) and the resulting hydrotreated VGO undergoes hydrocracking in the main reactor (R2) to convert a major part of it into light hydrocarbons. The reactor effluents are first separated into hydrogen-rich gas and hydrocarbon liquid, the hydrogen rich gas is recycled back to above two reactors (R1 and R2) and the hydrocarbon liquid is fractionated into several different grades of petroleum products in a series of fractionators (Fs). Since it is essentially impossible to accomplish 100% conversion in the reaction, a portion of the feed not converted to diesel and lighter products ends up as the final fractionator bottom stream.

**[0003]** In fact, fuels hydrocrackers are normally designed such that the per-pass conversion (conversion achieved by a single passage through the hydrocracking reactor) is around 60%. The unconverted oil (UCO) is then either sent to storage as a semi-final product (this type of operation is called "once-through mode") or recycled back to the main reactor (R2) for further cracking to increase the overall conversion (this type of operation is called "recycle mode"). A hydrocracking process with partial recycle of the unconverted fraction is disclosed in US-A-4 983 273.

**[0004]** Being a mixture of highly saturated hydrocarbons, the UCO has many desirable characteristics such as high viscosity index, which is one of the most important properties for lube base oil. Table 1 shows typical properties of VGO and UCO for overall conversion of 85% and per-pass conversion of 60%.

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**Table 1**  
**The Properties of the VGO and the UCO**

Properties	VGO	UCO
API Gravity	22	38
Distillation <sup>1</sup> °C		
- IBP <sup>**</sup> / 5%	260/340	350/370
- 10% / 20%	372/396	385/398
- 30% / 40%	415/434	410/422
- 50% / 60%	445/460	435/446
- 70% / 80%	475/492	458/474
- 90% / 95%	516/538	496/515
- FBP <sup>***</sup> / %recovery	547/98.5	536/99.0
Hydrogen, wt%	12.0	15.0
Nitrogen, wppm	800	4.0
Sulfur, wt%	3.0	0.0009
Aniline point °C	78	118
Pour Point °C	33	38
Viscosity, cst		
@ 40 °C	49.9	19.3
@ 60 °C	19.4	10.7
@ 100 °C	6.35	4.4
Viscosity Index	64	143
Saturation Degree of Hydrocarbon, wt%	31	98

<sup>1</sup> ASTM D-1160, @ 760 mmHg    <sup>\*\*</sup> Initial Boiling Point

<sup>\*\*\*</sup> Final Boiling Point

[0005] From the economic standpoint, it is more advantageous to utilize the UCO for high quality lube base oil after further processing such as dewaxing and stabilization than use it as fuel oil blending stock or recycle it to the hydrocracking reactor. Some refineries are known to be producing lube base oil with very high viscosity index using the UCO generated from a fuels hydrocracker. For example, a refinery produces VHVI (Very High Viscosity Index) lube base oil at their lube base oil plant utilizing the UCO from their fuels hydrocracker with once-through mode. The hydrocracker plant is located far away from the lube base oil plant.

[0006] However, the above conventional method for manufacturing lube base oil from the UCO in that plant has several problems. The UCO generated from the fuels hydrocracker is fed to the lube base oil plant. In that process, several existing units are being utilized including a vacuum distillation unit, a solvent extraction unit, a solvent dewaxing unit and so on in a "blocked mode" and becomes quite cumbersome with rather low operation efficiency.

[0007] For the above-mentioned plant, it becomes especially so, because the existing vacuum distillation unit was originally designed for processing atmospheric residue (AR). It is even necessary to blend the UCO with heavier stocks such as vacuum residue (VR) before feeding it to the existing vacuum distillation unit. For a better understanding of the background of the present invention, the description for a typical fuels hydrocracker in recycle mode is given below. And refer to the enclosed Figure 1.

[0008] Atmospheric residue (AR) is fed into the first vacuum distillation unit (V1) to produce a vacuum gas oil (VGO).

The VGO is then hydrotreated in the first reactor (R1) for the removal of impurities such as sulfur, nitrogen, oxygen and metals. The resulting treated VGO is then hydrocracked to yield a variety of hydrocarbon products in the second reactor (R2). These hydrocarbons are separated in a series of fractionators (Fs) to produce various light oil products and diesel oil.

5 [0009] However, not all of the cracked hydrocarbons are converted into diesel and lighter products. A substantial portion of the hydrocarbons remains unconverted. Most of such unconverted oil is sent back to the second reaction unit (R2) for further conversion. With high-endpoint vacuum gas oil feedstocks, however, heavy refractory hydrocarbons and condensed polynuclear aromatic compounds could gradually accumulate in the fuels hydrocracker's internal recycle oil stream. Excessive concentration of those compounds can cause rapid decline in catalyst performance and  
10 degradation in product selectivity. In order to avoid such operational instability, a small bleed stream of unconverted oil becomes necessary to purge those compounds from the system and to maintain a suitable level of reaction activity. For that purpose, in general, the fuels hydrocracker in recycle mode recycles a small portion of the product fractionator bottoms back to the feed vacuum column (V1).

[0010] The purpose of such a recirculation scheme is to reject a portion of the refractory components and polynuclear aromatics to the vacuum residue. Such a scheme also minimizes the quantity of unconverted oil that must be purged from the product fractionator bottoms. The typical recirculation rate to the feed vacuum column is 15 to 25 liquid volume  
15 % of the total unconverted oil.

[0011] In addition, the unconverted oil from the fuels hydrocracker with high conversion has an average viscosity ranging from 4.0 to 4.5 cst at 100°C, which is too low to make 150 Neutral lube base oil. The 150 Neutral lube base  
20 oil is one of the grades with high demand and has viscosities ranging from 5.5 to 6.0 cst at 100°C. Consequently, a considerable amount of the unconverted oil at most of the existing refineries as stated above is not being utilized for lube oil production, and wasted typically in the form of fuel oil.

#### SUMMARY OF THE INVENTION

25 [0012] Therefore, the objectives of the present invention is to solve the above problems encountered in the prior arts and to provide a method for producing feedstocks of high quality lube base oil. The present invention will make it possible to use the desired portion of the unconverted oil efficiently during the operation of the fuels hydrocracker in recycle mode, thereby utilizing the facilities to the maximum.

30 [0013] And this invention is the first such approach to produce continuously feedstocks of high quality lube base oil with very high viscosity index and low volatility from the fuels hydrocracker in recycle mode.

[0014] In accordance with the first embodiment of the present invention(as shown in Figure 2A), the above objective can be accomplished by providing a method for producing feedstocks of high quality lube base oil, comprising the steps of distilling an atmospheric residue (AR) under vacuum in a first vacuum distillation unit (V1) to give a vacuum  
35 gas oil (VGO); hydrotreating the vacuum gas oil in a first reaction unit (R1) to remove impurities therefrom; hydrocracking the treated vacuum gas oil in a second reaction unit(R2) to yield light hydrocarbons; applying a series of fractional distillations (Fs) to separate light oil products and an unconverted oil; feeding said unconverted oil to a second vacuum distillation unit (V2) to produce feedstocks of high quality lube base oil, having desired viscosities; and recycling the remaining portion of unconverted oil from the second vacuum distillation unit (V2) to the second reaction unit (R2).

40 [0015] In accordance with the second embodiment of the present invention(as shown in Figure 2B), the above objective can be also accomplished by providing a method for producing feedstocks of high quality lube base oil, comprising the steps of: distilling an atmospheric residue (AR) under vacuum in a first vacuum distillation unit (V1) to give a vacuum gas oil (VGO); hydrotreating the vacuum gas oil in a first reaction unit (R1) to remove impurities therefrom; hydrocracking the treated vacuum gas oil in a second reaction unit (R2) to yield light hydrocarbons; applying a series  
45 of fractional distillations (Fs) to separate light oil products and an unconverted oil; feeding only a part of said unconverted oil to a second vacuum distillation unit (V2) to produce feedstocks of high quality lube base oil, having desired viscosities; and recycling the remaining portion of unconverted oil from the second vacuum distillation unit (V2) to the second reaction unit (R2), while recycling remainder of unconverted oil from said fractional distillations(Fs) to said second reaction unit(R2).

#### BRIEF DESCRIPTION OF THE DRAWINGS

50 [0016] Other objectives and aspects of the invention will become apparent from the following description of embodiments with reference to the following description of embodiments with reference to the accompanying drawings in which:  
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Fig. 1 is a block diagram illustrating a conventional fuels hydrocracker in recycle mode;  
Fig. 2A is a block diagram illustrating a fuels hydrocracker and a method for producing feedstocks of high quality



lube base oil according to the first embodiment of the present invention; and  
 Fig. 2B is a block diagram illustrating a fuels hydrocracker and a method for producing feedstocks of high quality lube base oil according to the second embodiment of the present invention.

## 5 DETAILED DESCRIPTION OF THE INVENTION

[0017] Hereinafter, the preferred embodiments of the present invention will be, in detail, described with reference to the drawings above.

10 [0018] Fig. 2A illustrates a fuels hydrocracker and a method for producing feedstocks of high quality lube base oil according to the first embodiment of the present invention.

[0019] As illustrated in Fig. 2A, an atmospheric residue (AR) is fed into a first vacuum distillation unit (V1) to give a vacuum gas oil which is subsequently subjected to the treatment of hydrogenation in a first reaction unit (R1).

15 [0020] The hydrogenating reaction proceeds, removing impurities, such as sulfur, nitrogen, oxygen and metals, from the VGO. The resulting treated vacuum gas oil enters a second reaction unit (R2) wherein the treated vacuum gas oil is hydrocracked to yield a variety of light hydrocarbons. These hydrocarbons are separated in a series of fractional distillation steps (Fs), to produce various light oil products including diesel oil.

20 [0021] In the meanwhile, a substantial quantity of feed hydrocarbons remains unconverted. All of this unconverted oil is sent to a second vacuum distillation unit (V2) wherein the UCO is distilled to produce feedstocks of high quality lube base oil in accordance with the first embodiment of the present invention. While the oils with desired viscosities are fractionated from the UCO in the second vacuum distillation unit (V2) and subsequently subjected to dewaxing and stabilization so as to produce the lube base oil, the remaining part of the UCO is sent back to the second reaction unit (R2).

25 [0022] Fig. 2B illustrates a fuels hydrocracker and a method for producing feedstocks of high quality lube base oil according to the second embodiment of the present invention. As shown in this figure, a part of the UCO is taken to the second vacuum distillation unit (V2), whereas the other part is sent back to the second reaction unit (R2).

[0023] In accordance with the present invention, the additional vacuum distillation unit (V2) operating under vacuum is provided, wherein feedstocks of high quality lube base oil with appropriate viscosity grades can be produced. For example, 150 Neutral, a viscosity grade in high demand and 100 Neutral which has viscosities ranging from about 3.8 to about 4.2 cst at 100°C can be produced as required.

30 [0024] It is preferable to operate the second vacuum distillation tower (V2) at temperature ranging from about 300 to about 380°C and pressure ranging from about 20 to about 300 mmHg at the tower bottom, according to the present invention.

35 [0025] Turning now to Fig. 1 of prior art, the amount of the UCO that is recycled to the second reaction unit (R2) is approximately 60 to 70% of the VGO feed. Approximately 75 to 85% of the UCO (approximately 50 to 56.7% of the VGO) is sent back to the second reaction unit (R2) through line 2, and approximately 15 to 25% of it (approximately 10 to 16.7% of the VGO) is sent back to the first vacuum distillation unit (V1) through line 1.

40 [0026] All or a part of the UCO proceed to the second vacuum distillation unit (V2) in accordance with the present invention, wherein it is fractionated to feedstocks of high quality lube base oil with desired viscosities. The lube base oil feedstock is approximately 15 to 25% of total UCO, which is equal to the amount sent back to the first vacuum distillation unit (V1) in the conventional process (Figure 1). The rest, which is approximately 75 to 85% of total UCO, is recycled to the second reaction unit (R2).

[0027] According to the present invention, the ratio of total UCO from the fractional distillation step (Fs) to the UCO recycled to the second reaction unit (R2) is preferably on the order of 1.05 to 2.0 : 1.

45 [0028] In accordance with the present invention, the ratio of the UCO proceeding to the second vacuum distillation unit (V2) to the UCO recycled to the second reaction unit (R2) from the second vacuum distillation unit (V2) is preferably on the order of 1.05 to 4.0 : 1.

50 [0029] As described above, it is unnecessary to send the UCO back to the first vacuum distillation unit (V1) in the present invention. This invention is the first approach to utilize the UCO for manufacturing high quality lube base oil with very high viscosity index and low volatility continuously from the fuels hydrocracker while recycling the unused portion of the UCO back to the hydrocracking reaction unit.

[0030] The preferred embodiment of the present invention will now be further described with reference to specific examples.

### EXAMPLE 1

55 [0031] A vacuum gas oil with the properties shown in Table 1 was processed in a hydrotreating reaction unit (R1) with a liquid hourly space velocity of 2.10 hr<sup>-1</sup> and treated with a catalyst, commercially available from Nippon Ketjen Company in Japan, model HC-K, at reactor average bed temperature of 386.1°C and reactor inlet pressure of 2,523

psig, using a hydrogen rate of 5,720 SCF/BBL of reactor feed.

[0032] Thereafter, the resulting vacuum gas oil along with the unconverted oil to be described later was processed in a hydrocracking reaction unit (R2) with a liquid hourly space velocity of  $1.26 \text{ hr}^{-1}$  and treated with a catalyst, commercially available from UOP Incorporated in USA, model HC-22, at reactor average bed temperature of  $393.8^{\circ}\text{C}$  and reactor inlet pressure of 2,500 psig, using a hydrogen rate of 7,520 SCF/BBL of reactor feed.

[0033] Subsequently, all of the treated oil was subjected to a series of separations and fractional distillation steps (Fs) as shown in Fig. 2A, to obtain diesel and lighter products, and to give the  $380^{\circ}\text{C}$  + unconverted oil with the properties shown in the Table 1.

[0034] All of the unconverted oil was charged to a vacuum distillation unit (V2) wherein a tower top temperature, a tower bottom temperature, a tower top pressure and a tower bottom pressure are  $80^{\circ}\text{C}$ ,  $325^{\circ}\text{C}$ , 75mmHg and 150mmHg, respectively and distilled, so as to give a light distillate(i) 33.0 LV%, an 100N distillate(ii) 8.3 LV% a middle distillate(iii) 11.7 LV% and a tower bottom product(iv), 150N light distillate 47.0 LV%.

[0035] From the above distillates, the 100N and the 150N distillates amounting to 25% of the unconverted oil fed to the vacuum distillation unit (V2), i.e. 100N; 5% and 150N; 20%, were drawn out, and the rest was mixed and recycled to the hydrocracking reaction unit (R2).

[0036] The properties of the distillates are shown in the following Table 2A.

## EXAMPLE 2

[0037] A vacuum gas oil with the properties shown in Table 1 was processed in a hydrotreating reaction unit (R1) with a liquid hourly space velocity of  $2.10 \text{ hr}^{-1}$  and treated with a catalyst, commercially available from Nippon Ketjen Company in Japan, model HC-K, at reactor average bed temperature of  $385.9^{\circ}\text{C}$  and reactor inlet pressure of 2,523 psig, using a hydrogen rate of 5,710 SCF/BBL of reactor feed.

[0038] Thereafter, the resulting vacuum gas oil along with unconverted oil to be described later was processed in a hydrocracking reaction unit (R2) with a liquid hourly space velocity of  $1.25 \text{ hr}^{-1}$  and treated with a catalyst, commercially available from UOP Incorporated in USA, model HC-22, at reactor average bed temperature of  $384.1^{\circ}\text{C}$  and reactor inlet pressure of 2,500 psig, using a hydrogen rate of 7,500 SCF/BBL of reactor feed.

[0039] Subsequently, the treated oil was subjected to a series of separations and fractional distillation steps (Fs) as shown in Fig. 2B, to obtain diesel and lighter products and to give the  $380^{\circ}\text{C}$  + unconverted oil with the properties shown in Table 1.

[0040] A half(50%) of the unconverted oil was recycled to the hydrocracking reaction unit (R2) and the other half (50%) was charged to a vacuum distillation unit (V2) wherein a tower top temperature, a tower bottom temperature, a tower top pressure and a tower bottom pressure are  $80^{\circ}\text{C}$ ,  $325^{\circ}\text{C}$ , 75mmHg and 150mmHg, respectively and was distilled so as to give a light distillate(i) 32.9 LV%, an 100N distillate(ii) 8.4 LV%, a middle distillate(iii) 11.8 LV% and a tower bottom product, 150N distillate(iv) 46.9 LV%.

[0041] From the above distillates, the 100N and the 150N distillates amounting to 50% of the unconverted oil fed to the vacuum distillation unit (V2), i.e. 100N : 10% and 150N : 40%, were drawn-out, and the rest was mixed and recycled to the hydrocracking unit (R2).

[0042] The properties of the distillates are shown in the following Table 2B.

Table 2A

The Properties of the Products from UCO Vacuum Distillation Unit(V2) (for Example 1)

Properties	Light Distil.	100 N Distil.	Middle Distil.	150 N Distil.
API Gravity	38.8	38.6	38.4	37.8
Distillation <sup>*</sup> °C				
- IBP <sup>**</sup> / 5 LV%	278/289	377/405	341/408	424/437
- 10% / 30%	305/402	406/412	410/424	442/458
- 50% / 70%	405/414	421/431	434/447	471/493
- 90% / 95%	430/437	446/453	469/483	514/519
- FBP <sup>***</sup>	462	482	520	523
Viscosity, cst				
@ 60 °C	7.63	8.50	9.26	13.89
@ 100 °C	3.45	3.80	4.19	5.70
Viscosity Index	143	154	179	172
Flash Point(COC) °C	143	220	192	248
Noack Volatility, %		14.9		4.8
Average Molecular Weight	347	387	403	456
Watson K Value	12.73	12.88	12.93	13.04
Pour Point, °C		30.7		35.0

<sup>\*</sup> ASTM D-1160, @ 760 mmHg, °C, Distil. : Distillate

<sup>\*\*</sup> Initial Boiling Point <sup>\*\*\*</sup> Final Boiling Point

Table 2B

The Properties of the Products from UCO Vacuum Distillation Unit(V2)(for Example 2)				
Properties	Light Distil.	100 N Distil.	Middle Distil.	150 N Distil.
API Gravity	38.9	38.6	38.3	37.8
Distillation <sup>*</sup> °C				
- IBP <sup>**</sup> / 5 LV%	275/288	378/404	339/407	425/438

<sup>\*</sup> ASTM D-1160, @ 760 mmHg, °C, Distil. : Distillate

<sup>\*\*</sup> Initial Boiling Point

Table 2B (continued)

The Properties of the Products from UCO Vacuum Distillation Unit(V2)(for Example 2)				
Properties	Light Distil.	100 N Distil.	Middle Distil.	150 N Distil.
- 10% / 30%	306/402	406/413	411/424	442/457
- 50% / 70%	404/413	420/431	433/446	476/495
- 90% / 95%	431/437	444/453	467/483	516/521
- FBP***	463	484	518	525
Viscosity, cst				
@ 60 °C	7.62	8.50	9.27	13.89
@ 100 °C	3.43	3.80	4.14	5.70
Viscosity Index	139	154	169	172
Flash Point(COC)	142	221	195	249
°C				
Noack Volatility, %		15.0		5.0
Average	346	388	402	457
Molecular Weight				
Watson K Value	12.72	12.88	12.92	13.04
Pour Point, °C		30.9		36.1

\*\*\* Final Boiling Point

[0043] As apparent from the above Examples and Tables, it is possible to produce feedstocks of high quality lube base oil of 100N and 150N showing very high viscosity index and low volatility in accordance with the present invention.

[0044] In addition, withdrawing part of the UCO prevents the accumulation of heavy refractory hydrocarbons and condensed polynuclear aromatic compounds and frees capacity in the vacuum distillation unit (V1) and hydrotreating reaction unit (R1), allowing treatment of the vacuum gas oil in the same amount as the withdrawn lube base oil feedstock. Therefore, it has been proved that the present invention could utilize the facilities very efficiently.

[0045] Although the preferred embodiment of the present invention has been disclosed for illustrative purpose, those skilled in the art will appreciate that various modifications, addition and substitutions are possible, without departing from the scope and spirit of the present invention as disclosed in the accompanying claims.

#### Claims

1. A method for producing feedstocks of high quality lube base oil utilizing the unconverted oil of fuel hydrocracker, comprising the steps of:

distilling an atmospheric residue under vacuum in a first vacuum distillation unit (V1) to give a vacuum gas oil; hydrotreating the vacuum gas oil in a first reaction unit (R1) to remove impurities therefrom; hydrocracking the treated vacuum gas oil in a second reaction unit (R2) to yield light hydrocarbons; applying a series of fractional distillations (Fs) to separate light oil products and an unconverted oil; feeding all of said unconverted oil to a second vacuum distillation unit (V2) to produce feedstocks of high quality lube base oil, having desired viscosities; and recycling the remaining portion of unconverted oil from the second vacuum distillation unit (V2) to the second reaction unit (R2).

2. A method according to Claim 1, wherein the lube base oil feedstocks having a desired viscosity range are subjected to further dewaxing and stabilization process, while the remaining portion of unconverted oil from the second vacuum distillation unit (V2) is recycled to the second reaction unit (R2).



3. A method according to Claim 1, wherein the second vacuum distillation unit (V2) is operated at tower bottom temperature ranging from 300 to 380°C under tower bottom pressures ranging from 20 to 300mmHg.
4. A method according to Claim 1, wherein the ratio of total unconverted oil from the fractional distillations (Fs) to the unconverted oil recycled to the second reaction unit (R2) is from 1.05 to 2.0 : 1.
5. A method according to Claim 1, wherein the ratio of the unconverted oil sent to the second vacuum distillation unit (V2) to the unconverted oil recycled to the second reaction unit (R2) from the second vacuum distillation unit (V2) is from 1.05 to 4.0 : 1.
6. A method for producing the feedstocks of high quality lube base oil, comprising the steps of;
  - distilling an atmospheric residue (AR) under vacuum in a first vacuum distillation unit (V1) to give a vacuum gas oil (VGO);
  - hydrotreating the vacuum gas oil in a first reaction unit (R1) to remove impurities therefrom;
  - hydrocracking the treated vacuum gas oil in a second reaction unit (R2) to yield light hydrocarbons;
  - applying a series of fractional distillations (Fs) to separate light oil products and an unconverted oil;
  - feeding only a part of said unconverted oil to a second vacuum distillation unit (V2) to produce feedstocks of high quality lube base oil, having desired viscosities; and
  - recycling the remaining portion of unconverted oil from second vacuum distillation unit (V2) to the second reaction unit (R2), while recycling remainder of unconverted oil from said fractional distillations(Fs) to said second reaction unit(R2).
7. A method according to Claim 6, wherein the lube base oil feedstocks having a desired viscosity range are subjected to further dewaxing and stabilization process, while the remaining portion of unconverted oil from the second vacuum distillation unit (V2) is recycled to the second reaction unit (R2).
8. A method according to Claim 6, wherein the second vacuum distillation unit (V2) is operated at tower bottom temperature ranging from 300 to 380°C under tower bottom pressures ranging from 20 to 300 mmHg.
9. A method according to Claim 6, wherein the ratio of total unconverted oil from the fractional distillations (Fs) to the unconverted oil recycled to the second reaction unit (R2) is from 1.05 to 2.0 : 1.
10. A method according to Claim 6, wherein the ratio of the unconverted oil sent to the second vacuum distillation unit (V2) to the unconverted oil recycled to the second reaction unit (R2) from the second vacuum distillation unit (V2) is from 1.05 to 4.0 : 1.

#### Patentansprüche

1. Verfahren zur Herstellung von Hochqualitätsschmierölchargen unter Verwendung des nicht umgesetzten Öls eines Brennstoff-Hydrocrackers, umfassend die Stufen, daß man: einen atmosphärischen Rückstand im Vakuum in einer ersten Vakuumdestillationseinheit (V1) destilliert, was ein Vakuumgasöl ergibt;
  - das Vakuumgasöl in einer ersten Reaktionseinheit (R1) mit Wasserstoff behandelt, um Verunreinigungen daraus zu entfernen;
  - das behandelte Vakuumgasöl in einer zweiten Reaktionseinheit (R2) hydrierend spaltet, was Leichtkohlenwasserstoffe liefert;
  - eine Reihe von fraktionierten Destillationen (Fs) anwendet, um Leichtölprodukte und nicht umgesetztes Öl zu trennen;
  - das gesamte nicht umgesetzte Öl einer zweiten Vakuumdestillationseinheit (V2) zuführt und Schmierölchargen mit hoher Qualität zu erzeugen mit der gewünschten Viskosität und
  - den verbleibenden Teil des nicht umgesetzten Öls aus der zweiten Vakuumdestillationseinheit (V2) in die zweite Reaktionseinheit (R2) zurückführt.
2. Verfahren nach Anspruch 1, worin die Schmierölchargen mit einem gewünschten Viskositätsbereich einem weiteren Entwachsungs- und Stabilisierungsverfahren unterzogen werden, während der verbleibende Teil des nicht umgesetzten Öls aus der zweiten Vakuumdestillationseinheit (V2) in zweite Reaktionseinheit (R2) zurückgeführt

wird.

3. Verfahren nach Anspruch 1, worin die zweite Vakuumdestillationseinheit (V2) bei einer Kolonnenboden-temperatur im Bereich von 300 bis 380°C und einem Kolonnenbodendruck im Bereich von 20 bis 300 mmHg betrieben wird.
4. Verfahren nach Anspruch 1, worin das Verhältnis von allem nicht umgesetztem Öl aus den fraktionierten Destillationen (Fs) zu nicht umgesetztem Öl, das in die zweite Reaktionseinheit (R2) zurückgeführt wird, 1,05 bis 2,0:1 ist.
5. Verfahren nach Anspruch 1, worin das Verhältnis von nicht umgesetztem Öl, das in die zweite Vakuumdestillationseinheit (V2) geführt wird, zu dem nicht umgesetzten Öl, das in die zweite Reaktionseinheit (R2) von der zweiten Vakuumdestillationseinheit (V2) zurückgeführt wird, 1,05 bis 4,0:1 ist.
6. Verfahren zur Herstellung von Schmierölchargen mit hoher Qualität umfassend die Stufen, daß man:
  - einen atmosphärischen Rückstand (AR) im Vakuum in einer ersten Vakuumdestillationseinheit (V1) destilliert, was ein Vakuumgasöl (VGO) ergibt;
  - das Vakuumgasöl in einer ersten Reaktionseinheit (R1) hydrierend behandelt, um Verunreinigungen daraus zu entfernen;
  - das behandelte Vakuumgasöl in einer zweiten Reaktionseinheit (R2) hydrierend spaltet, was Leichtkohlenwasserstoffe liefert;
  - eine Reihe von fraktionierten Destillationen (Fs) anwendet, um Leichtölprodukte und nicht umgesetztes Öl zu trennen;
  - nur einen Teil des nicht umgesetzten Öls einer zweiten Vakuumdestillationseinheit (V2) zuführt, um Schmierölchargen mit hoher Qualität zu erzeugen mit der gewünschten Viskosität und
  - den verbleibenden Teil des nicht umgesetzten Öls aus der zweiten Vakuumdestillationseinheit (V2) in die zweite Reaktionseinheit (R2) zurückführt, während der Rest des nicht umgesetzten Öls aus den fraktionierten Destillationen (Fs) in die zweite Reaktionseinheit (R2) zurückgeführt wird.
7. Verfahren nach Anspruch 6, worin die Schmierölchargen mit einem gewünschten Viskositätsbereich einem weiteren Entwachsungs- und Stabilisierungsverfahren unterzogen werden, während der restliche Teil des nicht umgesetzten Öls aus der zweiten Vakuumdestillationseinheit (V2) in die zweite Reaktionseinheit (R2) zurückgeführt wird.
8. Verfahren nach Anspruch 6, worin die zweite Vakuumdestillationseinheit (V2) bei einer Kolonnenboden-temperatur im Bereich von 300 bis 380°C und einem Kolonnenbodendruck im Bereich von 20 bis 300 mmHg betrieben wird.
9. Verfahren nach Anspruch 6, worin das Verhältnis von gesamtem nicht umgesetztem Öl aus den fraktionierten Destillationen (Fs) zu dem nicht umgesetzten Öl, das zu der zweiten Reaktionseinheit (R2) zurückgeführt wird, 1,05 bis 2,0:1 ist.
10. Verfahren nach Anspruch 6, worin das Verhältnis von nicht umgesetztem Öl, daß der zweiten Vakuumdestillationseinheit (V2) zugeführt wird, zu dem nicht umgesetzten Öl, das der zweiten Reaktionseinheit (R2) aus der zweiten Vakuumdestillationseinheit (V2) zugeführt wird, 1,05 bis 4,0:1 ist.

#### Revendications

1. Procédé de production de charges de départ pour des huiles lubrifiantes de base de haute qualité utilisant l'huile non convertie provenant d'une unité d'hydrocraquage de combustibles, qui comprend les étapes consistant:
  - à distiller un résidu atmosphérique sous vide dans une première unité (V1) de distillation sous vide pour obtenir un gasoil sous vide;
  - à effectuer l'hydrotraitement du gasoil sous vide dans une première unité de réaction (R1) pour en éliminer les impuretés;
  - à hydrocraquer le gasoil sous vide traité dans une seconde unité de réaction (R2) pour obtenir des hydrocarbures légers;
  - à effectuer une série de distillations fractionnées (Fs) pour séparer les huiles légères produites et une huile non convertie;

à charger la totalité de cette huile non convertie dans une seconde unité (V2) de distillation sous vide pour produire des charges de départ pour huile lubrifiante de base de haute qualité, ayant des viscosités voulues; et à recycler la partie restante de l'huile non convertie de la seconde unité (V2) de distillation sous vide à la seconde unité de réaction (R2).

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2. Procédé suivant la revendication 1, dans lequel les charges de départ pour huile lubrifiante de base ayant une plage de viscosité désirée sont soumises en outre à une opération de déparaffinage et de stabilisation, tandis que la partie restante de l'huile non convertie est recyclée de la seconde unité (V2) de distillation sous vide à la seconde unité de réaction (R2).

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3. Procédé suivant la revendication 1, dans lequel la seconde unité (V2) de distillation sous vide est conduite à une température à la base de la tour allant de 300 à 380°C sous des pressions à la base de la tour allant de 20 à 300 mm de mercure.

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4. Procédé suivant la revendication 1, dans lequel le rapport de l'huile non convertie totale venant des distillations fractionnées (Fs) à l'huile non convertie recyclée à la seconde unité de réaction (R2) va de 1,05 à 2,0:1.

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5. Procédé suivant la revendication 1, dans lequel le rapport de l'huile non convertie envoyée à la seconde unité (V2) de distillation sous vide à l'huile non convertie recyclée à la seconde unité de réaction (R2) depuis la seconde unité (V2) de distillation sous vide va de 1,05 à 4,0:1.

6. Procédé de production de charges de départ d'huile lubrifiante de base de haute qualité, qui comprend les étapes consistant:

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à distiller un résidu atmosphérique (AR) sous vide dans une première unité (V1) de distillation sous vide pour obtenir un gasoil sous vide (VGO);

à effectuer l'hydrotraitement du gasoil sous vide dans une première unité de réaction (R1) pour en éliminer les impuretés;

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à effectuer l'hydrocraquage du gasoil sous vide traité dans une seconde unité de réaction (R2) pour obtenir des hydrocarbures légers;

à effectuer une série de distillations fractionnées (Fs) pour séparer les huiles légères produites et une huile non convertie;

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à charger uniquement une partie de cette huile non convertie dans une seconde unité (V2) de distillation sous vide pour produire des charges de départ pour huile lubrifiante de base de haute qualité, ayant des viscosités voulues; et

à recycler la partie restante de l'huile non convertie de la seconde unité (V2) de distillation sous vide à la seconde unité de réaction (R2), tout en recyclant le reste de l'huile non convertie des distillations fractionnées (Fs) à la seconde unité de réaction (R2).

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7. Procédé suivant la revendication 6, dans lequel les charges de départ pour huile lubrifiante de base ayant une plage de viscosité voulue sont soumises en outre à une opération de déparaffinage et de stabilisation, tandis que la partie restante de l'huile non convertie est recyclée de la seconde unité (V2) de distillation sous vide à la seconde unité de réaction (R2).

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8. Procédé suivant la revendication 6, dans lequel la seconde unité (V2) de distillation sous vide est conduite à une température à la base de la tour allant de 300 à 380°C sous des pressions à la base de la tour allant de 20 à 300 mm de mercure.

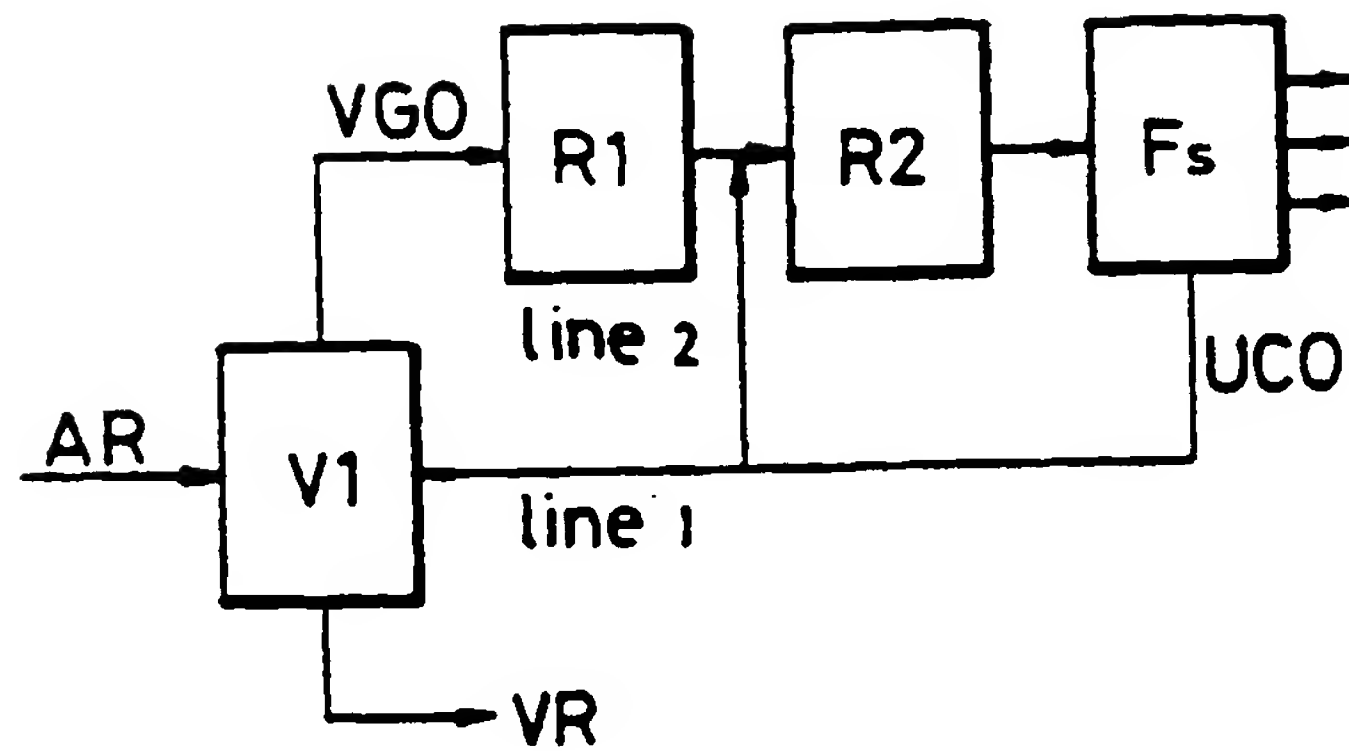
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9. Procédé suivant la revendication 6, dans lequel le rapport de l'huile non convertie totale venant des distillations fractionnées (Fs) à l'huile non convertie recyclée à la seconde unité de réaction (R2) va de 1,05 à 2,0:1.

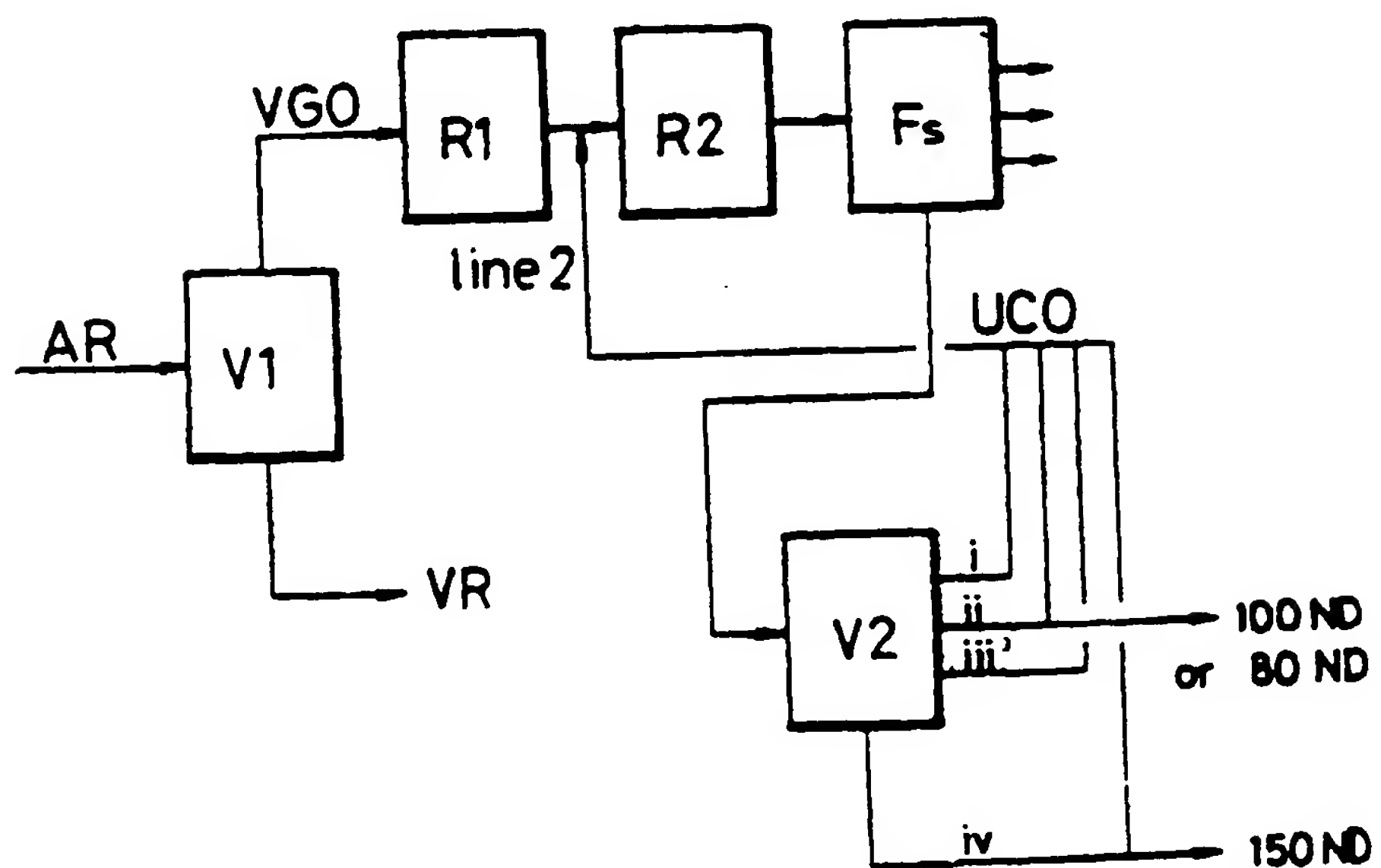
10. Procédé suivant la revendication 6, dans lequel le rapport de l'huile non convertie envoyée à la seconde unité (V2) de distillation sous vide à l'huile non convertie recyclée à la seconde unité de réaction (R2) depuis la seconde unité (V2) de distillation sous vide va de 1,05 à 4,0:1.

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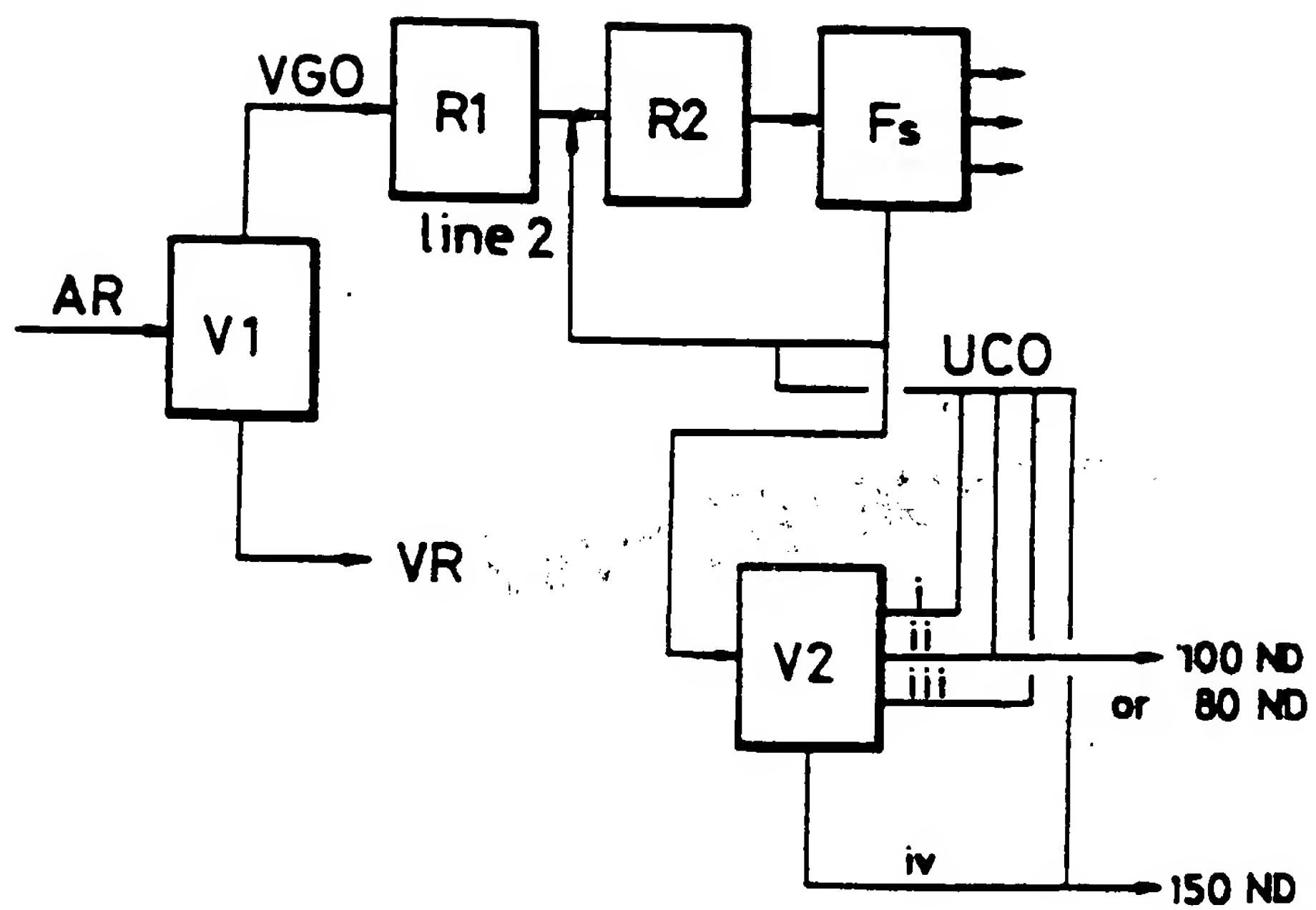
*Fig. 1*



*Fig. 2A*



*Fig. 2B*





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